

Split 09/10/22

Work Order ID 52684-2



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October 7, 2009 10:23:36 AM

Item ID: D3180-041
Revision ID: B
Item Name: Strut Assembly

Accept



Setup Start



Stop



Start Date: 07/10/2009 Start Qty: 5.00
Required Date: 15/10/2009 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: PL Date: 09-10-7 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3180	Rev B								
100	NC BRAKE	0.00							
	Brake NC								
	Brake NC								
	Memo	0.00							
	1-Punch 3/4" 316 Seamless Tubing with 3/4" O.D. x 0.049" wall to length as per Dwg D3180 using DT8313 Ensure rotate and punch one end only as per view B-B as per Dwg. D3180								
110	Small Fab	0.00							
	Small Fab								
	Small Fab								
	Memo	0.00							
	1-Drill Ø0.203" as per Dwg D3180 2-Bend one side only as per Dwg D3180 Identify as D3180-1 3-Deburr edges								
120	QCS- Inspect part completeness to step on W/O	0.00							
	QC								
	Quality Control								
	Memo	0.00							

09-10-20

09/10/20

09/10/21

09/10/21

5x

5x

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Cust Item ID:
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum Memo START TIME: 8:45am 9:15am FINISH TIME: 4:00pm	0.00 0.00	1112260	09/10/22		(X5)	6		
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	BR	09-10-22		(5)			
150 Small Fab Small Fab	Small Fab Memo 1-Assemble as per Dwg D3180	0.00 0.00	M-L	09/10/22		(3X)			

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Item ID: D3180-041
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Item Name: Strut Assembly

Accept



Setup Start
Stop



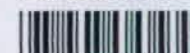
Start Date: 07/10/2009 Start Qty: 5.00
Required Date: 15/10/2009 Req'd Qty: 5.00



Cust Item ID:
Customer:

Reference:

Run Start
Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
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2 8 09/10/22

83

4

170 Packaging Packaging	Identify as per dwg & Stock Location: <u>271</u> Memo	0.00 0.00							
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9/10/22 SP

180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
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09/10/22 JH

11/09/10-22

Picklist Print

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Page 1

Work Order ID: 52684

Parent Item: D3180-041RevB

Parent Item Name: Strut Assembly



Comments:

Start Date: 07/10/2009

Required Date: 15/10/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-10  Screw		Purchased	No			100	Each	237.0000	5.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	237	
111425	37	
112794 ✓	100	
112828 ✓	100	

M-L 09/10/22
M112794 (2x)
M112828 (3x)

A1449

Grommet

Purchased	No					150	Each	1,214.000	5.0000	
-----------	----	--	--	--	--	-----	------	-----------	--------	---

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1214	
1487	1214 ✓	

M-L 09/10/22
M1487 (5x)

Picklist Print

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Work Order ID: 52684

Parent Item: D3180-041RevB

Parent Item Name: Strut Assembly



Comments:

Start Date: 07/10/2009

Required Date: 15/10/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 		Purchased	No			150	Each	1,942.000	15.0000			
Washer												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	1942	
105442	95	
109059	2	
109840	23	
110985	202	
111279	5	
111668	64	
112314	1000	
112369 ✓	551	

m-l 09/10/22

M112369

✓ BLRS-001



Pip Pin

Purchased

No

150

Each

3.0000

5.0000



Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	3	
104700	2 ✓	
15608	1 ✓	

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M1104700 (2x)
M15608 (1x)

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Shop Packet Print

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Picklist Print

Page 3

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Work Order ID: 52684

Parent Item: D3180-041RevB

Parent Item Name: Strut Assembly

Comments:



Start Date: 07/10/2009

Required Date: 15/10/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2022-101RevN/A Manufactured

No

150

Each

591.0000

10.0000



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST504

591

45885 ✓

391

50746

100

52325

100

m-l 09/10/22
M45885

✓ D2690-6RevB2

Manufactured

No

150

Each

32.0000

5.0000



Lanyard Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

44048

2

Main Warehouse

ST41

30

50665

30

m-l 09/10/22
M44048 (3x) *

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Work Order ID: 52684

Parent Item: D3180-041RevB

Parent Item Name: Strut Assembly



Comments:

Start Date: 07/10/2009

Required Date: 15/10/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.065 		Purchased	No			150	f	134.8000	18.8595			
304 RD Tube .750 x .065W												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	134.8	
104565	14.8	
110113	120	

MS21042L3

Purchased

No

150

Each

3,561.000

5.0000

Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3561	
110844	32	
111274	41	
111668	988	✓
112314	2000	
112385	500	

\$4 15.0870 *
4.000
8009/10/21

M-1 09/10/22
M111668 (5X)

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Shop Packet Print

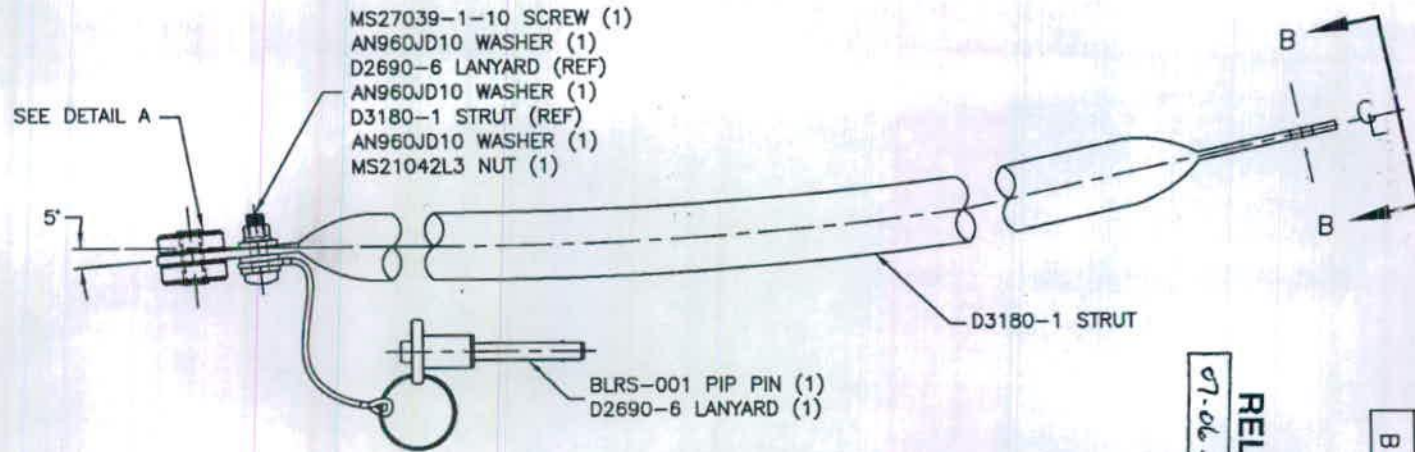
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0. 52684
PL 0910-7

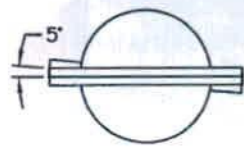
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>CE</i>	APPROVED <i>SC</i>	HAMKESBURY, ONTARIO, CANADA
DATE 07.05.23	DRAWING NO. D3180	REV. B
	TITLE STRUT ASSEMBLY	SHEET 1 OF 2
		SCALE 1:2
A	03.01.06	NEW ISSUE
B	07.05.23	CURVE ADDED

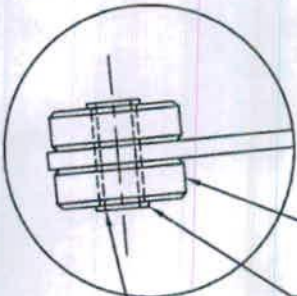
RELEASED
07.06.08



D3180-041 STRUT ASSEMBLY



VIEW B-B
SCALE 1:1



DETAIL A
SCALE 1:1

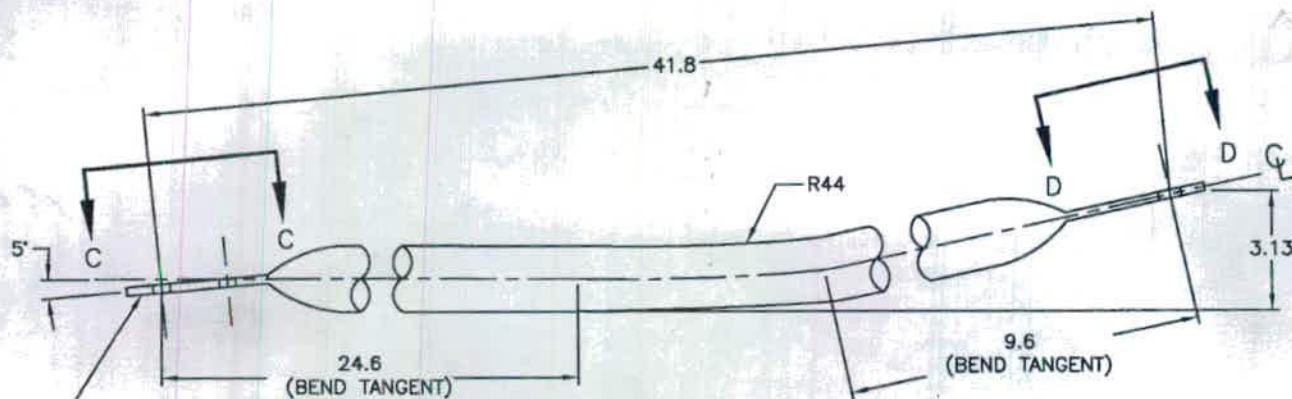
D2022-101 SPACER
(2 PLACES)
SWAGE D2022-101 SPACERS ONTO
D3180-1 STRUT USING A1449 GROMMET
(1 PLACE)
A1449 GROMMET
(REF)

QTY	PART NUMBER	DESCRIPTION
X	D3180-041	STRUT ASSEMBLY
1	D3180-1	STRUT
1	D2690-6	LANYARD
2	D2022-101	SPACERS
3	AN960JD10	WASHER
1	MS27039-1-10	SCREW
1	BLRS-001	PIP PIN
1	MS21042L3	NUT
1	A1449	GROMMET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 526841
09-10-7
R

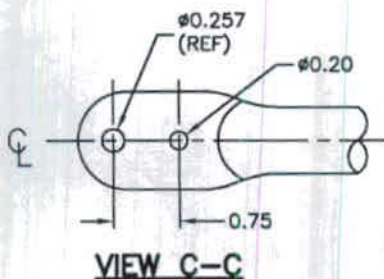
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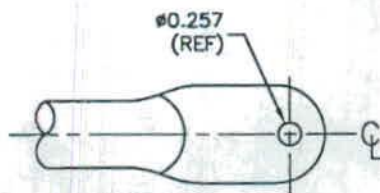
D3180-1 STRUT

USE PUNCH DT8117
BOTH ENDS
(DIMS PER SPEC. CONTROL DWG D2638)

RELEASED
07.06.08



VIEW C-C



VIEW D-D

NOTES

- 1) MATERIAL: AISI 304/316/318 SS TUBE,
ø0.75 X 0.065 WALL
(REF. DART SPEC M304TR0.750W.065)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART
QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH PART P/N "D3180-041" USING
FINE POINT PERMANENT INK MARKER

DESIGN	✓	DRAWN BY	✓	DART AEROSPACE LTD
CHECKED	✓	APPROVED	✓	HAMKESBURY, ONTARIO, CANADA
DATE	07.05.23	DRAWING NO.	D3180	REV. B
		TITLE	STRUT ASSEMBLY	SHEET 2 OF 2
				SCALE 1:2

